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(54) **Friction stir welding**

(57) Disclosed is a rotating tool(11) for friction stir welding capable of providing uniform welding strength by friction stir welding over the entire length of a butted portion of works(W1, W2) including tack-welded sections by excess metals(S), and method and apparatus of friction stir welding using the rotating tool(11). The rotating tool(11) for friction stir welding has a cutting blade (11A) for removing the excess metals(S). By rotating and moving the rotating tool(11) along the butted portion of the two works(W1, W2), friction stir welding is carried out while removing the excess metals(S) by using the cutting blade(11A). The rotating tool(11) is provided with a shoulder portion(14) at a tip end side of a tool body (12) and a pin(15) at a tip end of the shoulder portion (14). Two cutting blades(11A) may be symmetrically provided from the shoulder portion(14) to a tip end portion of the tool body(12).

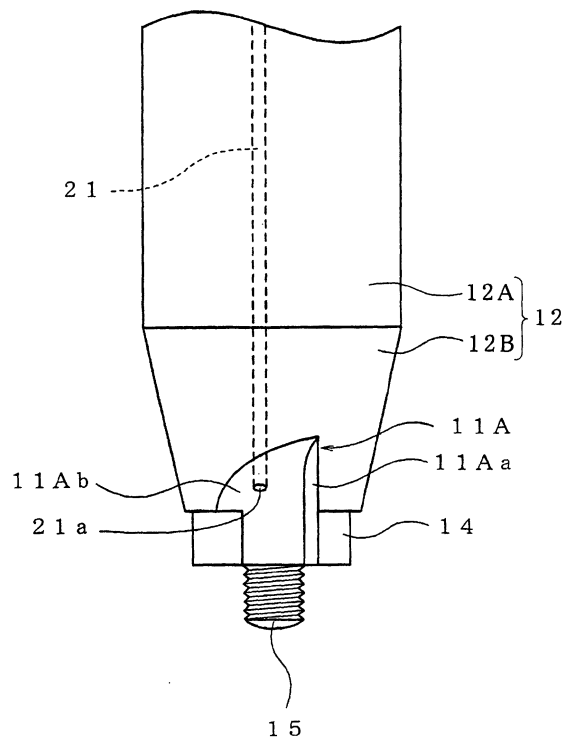


Fig.2



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EP 02 25 8015

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Place of search THE HAGUE		Date of completion of the search 17 November 2003	Examiner Haegeman, M
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